CLAIMS

What is claimed is:

1. A method **(10)** of making a part comprising the steps of:

placing an insert **(12)** having sides **(14)** and an open top **(16)** and a bottom surface **(18)** into a mold cavity**(20)**,

injecting an insulating layer composition **(28)** into said mold cavity **(20)** to bond to the bottom surface **(18)** and the sides **(14)** of the insert **(12)** to form an insulating layer **(30)** having sides **(32)** and a bottom **(34)** to expose the open top **(16)**, and

injecting a part composition **(44)** over the bottom **(34)** and the sides **(32)** of the insulating layer **(30)** to expose the open top **(16)**.

2. A method **(10)** as set forth in claim 1 further defined as placing the insert **(12)** with the insulating layer **(30)** into a second mold cavity **(36)** in a second mold **(42)** and injecting the part composition **(44)** into said second mold cavity **(36)**.

3. A method **(10)** as set forth in claim 2 including forming the insulating layer **(30)** from a thermoset elastomer.

4. A method **(10)** as set forth in claim 3 wherein said thermoset elastomer includes a filler.

5. A method **(10)** as set forth in claim 4 including forming the insulating layer **(30)** from a thermoplasic elastomer.

6. A method **(10)** as set forth in claim 5 wherein said thermoplastic elastomer includes a filler.

7. A method **(10)** as set forth in claim 6 including forming the insulating layer **(30)** from a compressive polymer.

8. A method **(10)** as set forth in claim 7 wherein said compressive polymer includes a filler.

9. A method **(10)** as set forth in claim 8 including forming the insert **(12)** with a base **(50)** extending outwardly from the bottom surface **(18)** of the insert **(12)**.

10. A method **(10)** as set forth in claim 9 including forming the insert **(12)** with at least one anchor **(68)** extending outwardly from the sides **(14)** and between the open top **(16)** and the bottom surface **(18)** of the insert **(12)**.

11. A method **(10)** as set forth in claim 10 including forming the insert **(12)** into said second mold cavity **(36)** is further defined as placing the insert **(12)** with a threaded bore **(52)** extending inwardly from the open top **(16)** to the bottom surface **(18)**.

12. A method **(10)** as set forth in claim 11 including forming the insert **(12)** into said second mold cavity **(36)** is further defined as placing the insert **(12)** with a pin **(69)** having an external male thread **(70)**.

13. A method **(10)** as set forth in claim 12 including forming the insert **(12)** with a rectangular configuration.

14. A method **(10)** as set forth in claim 13 including forming the insert **(12)** with a round configuration.

15. A method **(10)** as set forth in claim 14 including forming the insert **(12)** from a polymer.

16. A method **(10)** as set forth in claim 15 including forming the insert **(12)** from a metal.

17. A method **(10)** as set forth in claim 1 including forming a shell **(54)** having inner **(56)** and outer **(58)** surfaces and a boss section **(60)** extending outwardly from the inner surface **(56)**.

18. A method **(10)** as set forth in claim 17 including forming the boss section **(60)** with top **(62)** and bottom **(64)** ends and a cavity **(66)** extending inwardly from the top end **(62)** to the bottom end **(64)** to hold the insert **(12)**.

19. A method **(10)** as set forth in claim 18 including forming the shell **(54)** from a polymer.

20. A method **(10)** as set forth in claim 19 including adding a dye to the part composition **(44)** before injecting the part composition **(44)** into said second mold cavity **(36)**.

21. A method **(10)** as set forth in claim 20 including adding a pigment to the part composition **(44)** before injecting the part composition **(44)** into said second mold cavity **(36)**.

22. A method **(10)** as set forth in claim 21 including injecting a paint **(48)** into said second mold cavity **(36)** over the part composition **(44)**.